

Date: Tuesday, 28/10/2008 3:26:29 PM
 User: Chantal Lavoie

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: CUPPED WASHER		
Job Number	: 43031						
Estimate Number	: 12908						
P.O. Number	:			Part Number	:	D36283	
This Issue	: 28/10/2008	S.O. No.	:	Drawing Number	:	D3628 REV B	
Prsh Rev.	:	NC		Project Number	:	N/A	
First Issue	:	/ /	Type	Drawing Revision	:	B	
Previous Run	:	32924		Material	:		
Written By	:			Due Date	:	14/11/2008	Qty: 500 Um: Each
Checked & Approved By	:	<u>IND 08.10.28</u>					
Comment	:	Est Rev:A New Issue 07-05-28 JLM Est Rev:B Removed Powder Coat 07-07-11 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
		Comment: Issue P/O: <u>7475</u> <i>C 208/10/28</i> Email or Ship DXF file to vendor Laser Cut D3628-1 flat pattern and form as per Dwg D3628 Possible Supplier: GFI Material release note is required
2.0	D36283	Cupped Washer
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 500.0000 Each(s) CUPPED WASHER
3.0	PACKAGING 1	PACKAGING RESOURCE #1
		Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure material certification is attached
4.0	QC6	DIMENSIONAL CHECK
		 <i>Post 11/26 0w</i>
		Comment: DIMENSIONAL CHECK
5.0	PACKAGING 1	PACKAGING RESOURCE #1
		 <i>S 09/11/28 4500</i>
		Comment: PACKAGING RESOURCE #1 Identify with P/N and B/N using a permanent fine point marker on under side of part, then Stock Location: <u>114</u>
		 <i>6/12/11 SP</i>

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 28/10/2008 3:26:29 PM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CUPPED WASHER

Job Number: 43031

Part Number: D36283

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/12/02 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-12-02

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

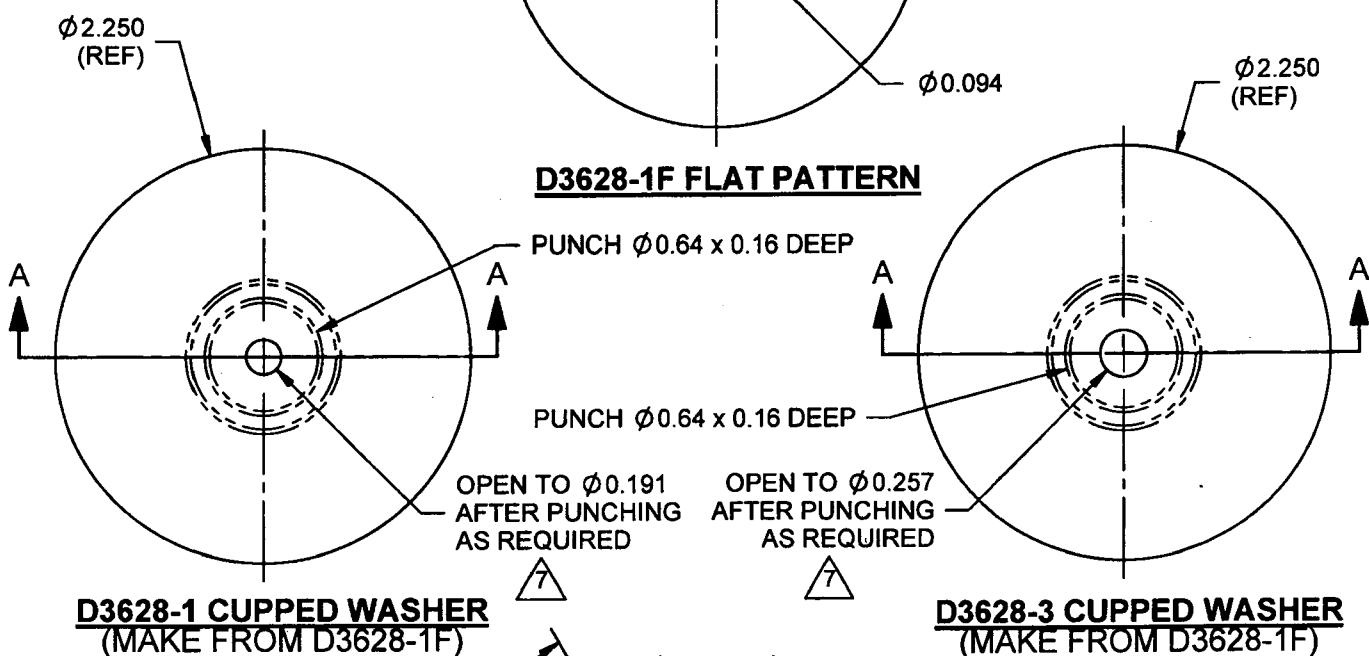
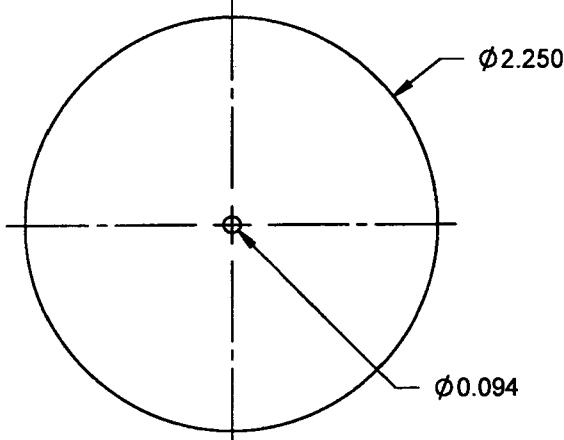
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>CB</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>CE</i>	APPROVED <i>CH</i>	DRAWING NO. D3628	REV. B	SHEET 1 OF 1
DATE 07.07.09		TITLE CUPPED WASHER	SCALE 1:1	
REV A	DATE 07.06.08	DESCRIPTION NEW ISSUE		
B	07.07.09	REMOVE POWDER COAT		

RELEASED07.07.09 *CH***NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 18 GAUGE (0.050 THICK) PER MIL-S-5019 (REF DART SPEC M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N "D3628-1/3" USING FINE POINT PERMANENT INK MARKER ON THE UNDERSIDE OF THE PART AS INDICATED
- 7) WHEN DRILLING OUT THE CENTRE HOLE AFTER PUNCHING, ENSURE THAT THE HOLE IS DRILLED CONCENTRIC TO THE CUPPED AREA, WITHIN 0.03

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *43031*



180 AVENUE LABROSSE
POINTE-CLAIRE, QUÉ., CANADA H9R 1A1
TÉL.: (514) 630-4877 - FAX: (514) 630-4849

C'est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.



BON DE LIVRAISON - SHIPPING MEMO

DATE DE LIVRAISON SHIPPING DATE	N° BON DE LIVRAISON SHIPPING MEMO NO.
2008/11/25	0408912

ENVOI / SOLD TO

EXPÉDIÉ À / SHIPPED TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON, K6A 1K7

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON, K6A 1K7

CODE DE CLIENT CUSTOMER CODE	N° CONTRAT DB NO.	N° COMMANDE PONO.	VIA SHIP VIA
DART GFI-0299	J013025	PO00007475	
500	D36283	CUPPED WASHER CERTIFICATE OF CONFORMANCE REQ <i>S oslw/29</i>	

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DES 5 JOURS DE LA RÉCEPTION
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

REÇU PAR / RECEIVED BY

CERTIFICATE OF COMPLIANCE

CERTIFICAT DE CONFORMITE



Member de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
170 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO. **2** OUR JOB NO

J0193025 SHIPPING MEMO **0408912**

DWG ISSUE

ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
	500 PCS	PO00007475	D36233	B	CUPPED WASHER	B
MATERIAL			SUPPLIED BY			MAT. REL. NO.
AMS 5513 304 ANN			TW METAL / ALLEGHENY LUDLUM			H/N # 947041

	PROCESS	ON FILE	PROCESSOR	RELEASE NOTE #
1	FIRST ARTICLE INSPECTION REPORT	ON FILE	GFI	CONFORMS
2				
3				
4				
5				
6				
7				
8				
9				

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE **25 NOVEMBER 2008**

G.F.I. Q.C. REP.

Galleon Wong

**DP12-001 REV 0 Bombardier Certificate of Compliance
TW Metals District Procedure**

Revision: 0

Revision Date: 04-03-00

Superseding: Initial

Page: 1 of 1

CERTIFICATE OF COMPLIANCE

FRAUD AND FALSIFICATION STATEMENT

The recording of false, fictitious, or fraudulent statements or entries on this document may be punished as a felony under federal statutes including federal law. Title 18 chapter 47.

CERTIFICATE OF COMPLIANCE

This certificate of compliance certifies that the material supplied on the purchase order number below complies in all respects with the material description and procurement specifications.

MERCURY FREE STATEMENT

We certify that mercury, radium, or alpha bearing instruments and / or equipment which might cause contamination have not been used in the manufacture, fabrication, assembly or testing of any material supplied by TW Metals Inc. Switches, glass thermometers, standard cell and other items containing the above elements may be used, but they will be located so as not to constitute a contamination hazard.

CUSTOMER NAME: GEF, Inc.

PURCHASE ORDER No. 0274610

ITEM No. 0001 SHIPPER INVOICE No. 03241965

MATERIAL SIS Sheet SPECIFICATION: AMS 5513

MANUFACTURING MILL: Alleghany

SIZE: .050 HEAT / LOT No. 947041

PART No. TS05048X96417 QUANTITY: 2 pcs

TEST DEPARTMENT CLERK: Janice Clark

AUTHORITY

Joe Schab
Director of Quality Assurance

*S
08/11/24*

M49199582

NOTICE OF SHIPMENT/
PACKING LIST

AL 6168-3 407

CERTIFICATE OF TEST

CUST. ORG. NO. & DATE	CUST. CODE	ACCEPTING MILL	SHIPPER NO.	PRODUCT CODE	MILL ORDER NUMBER	DATE SHIPPED
01012647 SOLD TO 1 FORMS DISTRIBUTION SHIP TO 1 SPEED SOLD TO	04/30/08 110977 82037-5 PRIME DSO 584	NEW CASTLE, IN. DO 26 PRI RATE QRTY SEC. DSO	S90040 GOVT CONTRACT	13020102060000 MATL	30-058-618 SHIPPING LOCATION	06/19/08 INVOICE
				1124 NEW CASTLE SHIP TO		076383

S
05/01/08

GRADE AND SPECIFICATIONS

ALLEGHENY STAINLESS STEEL TYPE 304-L SHEET C R COILS ANNEALED 2B FIN 3 EDGE (FMI 304L/304/302 ISSUE 7) (AMS 2248E) (AMS 5511H) (AMS 5513H) (AMS 5516P) (ASTM-A-262-02A PRA E/SCREEN PRA A) (ASTM-A-666-03) (S-400 DTD 10/31/07) (ASTM-A-240-07) (S-1000 DATED 1/2/08) (ASME-SA-240-07) (05/14/08 EXCEPT FMI 304L/304/302) (UNS S30403) (UNS S30200) (UNS S30400) (F-14, F-17, F-22, F-23, F-MASTER) (PWA 300 REV BH) (CONTROLLED TO PWA LCS REQUIREMENTS)

ITEM PCS DIMENSIONS W/G/L

ITEM	PCS	DIMENSIONS	W/G/L	HEAT #	COIL #	TEST #	GROSS	TARE	NET	THEO	TAG #	/ CD	SKID #
001B	1	48.	.050	947041	05228N786	7743524	17210	65	17145		169998		
P CUST IDENTITY 00624							17210	65	17145				
1 SKID													

TYPE HEAT/TEST

HEAT	947041	TYPE	C	MN	P	S	SI	CR	N	NI	MO	CU	N
HEAT	947041	.018	1.44	.032	.0005	.34	18.08	8.07	.33	.46	.04		
CHECK	7743524	.018	1.46	.031	.001	.35	18.14	8.03	.32	.45	.04		

ITEM TEST NO
001B 7743524

PSI *	PSI	IN 2"	% R/A	HARDNESS	BEND	A 262 PR E	CORROSION GRAIN
T 41900.	96500.	64.		84.HRBW	T PASS	PASS	9.
* Y.S. BY 0.2% OFFSET METHOD				82.HRBW			

ITEM TEST NO
001B 7743524

MELT SOURCE	P&W E-25
1.	TRAN BEND
2.	

METALLOGRAPHIC MAGNIFICATION: 100X ETCHEANT USED: OXALIC ACID

GRADE VERIFICATION WAS CARRIED OUT SPECTROSCOPICALLY

PAGE 01 - CONTINUED ON PAGE 02

CONSIGNEE: Please Note: This consignment was turned over to carrier in the class condition, being correctly loaded, at which time our responsibility for loss or damage in shipment ceased. For your protection please examine shipment as it arrives. If any shortage or damage is discovered, have a bid description made by transportation agent on waybill before signing.

Material Safety Data Sheets for this product have been supplied to your Purchasing Department. For an equipment copy phone 724-226-6577. CAUTION: Processing this material, dust, or solutions may cause lung disease. See Material Safety Data Sheets for further information.

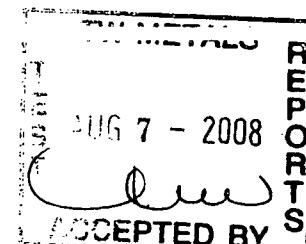
WARNING: Les bonnes d'information-sécurité de ce produit ont été fournies à votre département chargé des achats. Pour obtenir des exemplaires supplémentaires veuillez téléphoner au numéro suivant 724-226-6577. Attention: les instruments entraînant la production de vapeurs, poussières, ou solutions peuvent être cause de maladies pulmonaires. Pour plus de renseignements se référer aux feuillets d'information-sécurité.

REVIEWED BY Q.C.
Date 6/19/08 By [Signature]

06/19/08 14:09:31

The above is a true copy of data on file. The material and test results conform to the order contract and specification(s) as set forth in Allegheny Ludlum Order Acknowledgement.

See Mr. Xerhalis
Director, Corporate Quality Assurance



M49199582

NOTICE OF SHIPMENT/
PACKING LIST

CUST. ORD. NO. & DATE

01012647

FORMS DISTRIBUTION

SOLD TO

1

SHIP TO

SPEC

SOLD TO

CUST. CODE
04/30/08 110977NEW
REPEAT
ORDER
82037-5
PRIME
DSO
584ACCEPTING MILL
CASTLE, IN.
DO PRY
RATE CTRY
26
SEC.SHIPPER NO.
590040
GOVT CONTRACTPRODUCT CODE
13020102060000
MATL
1124 NEW CASTLE
SHIP TO

CERTIFICATE OF TEST

AL 6168-3 407

MILL ORDER NUMBER
30-058-618
SHIPPING LOCATION
IN 076383DATE SHIPPED
06/19/08
INVOICE

GRADE AND SPECIFICATIONS

ALLEGHENY STAINLESS STEEL TYPE 304-L SHEET C R COILS ANNEALED 2B FIN 3 EDGE (FMI 304L/304/302 ISSUE 7) (AMS 2248E) (AMS 5511H) (AMS 5513H) (AMS 5516P) (ASTM-A-262-02A PRA E/SCREEN PRA A) (ASTM-A-666-03) (S-400 DTD 10/31/07) (ASTM-A-240-07) (S-1000 DATED 1/2/08) (ASME-SA-240-07) (05/14/08 EXCEPT FMI 304L/304/302) (UNS S30403) (UNS S30200) (UNS S30400) (F-14, F-17, F-22, F-23, F-MASTER) (PWA 300 REV BH) (CONTROLLED TO PWA LCS REQUIREMENTS)

AUSTENITIC STAINLESS STEELS ARE SOLUTION ANNEALED AT 1900 DEGREES FAHRENHEIT MINIMUM (1038 C) AND RAPIDLY COOLED TO DEVELOP THE SPECIFIED PROPERTIES. EVIDENCE OF CONFORMANCE IS PROVIDED BY THE ABILITY OF THE MATERIAL TO MEET THESE SPECIFIED MECHANICAL AND CORROSION REQUIREMENTS

ALLEGHENY LUDLUM DOES NOT USE MERCURY IN THE TESTING OR PRODUCTION OF ITS PRODUCTS. TO THE BEST OF ALLEGHENY LUDLUM'S KNOWLEDGE, UNDERSTANDING, AND BELIEF, THIS MATERIAL WAS NOT CONTAMINATED BY MERCURY WHILE IT WAS BEING PRODUCED IN OUR FACILITIES.

NO WELDS/WELD REPAIRS PERFORMED.

CARRIER - KAPLAN TRUCKING

- THE FOLLOWING MELT SOURCE CAN BE INTERPRETED AS FOLLOWS:
1. - MATERIAL MELTED AND ROLLED IN THE UNITED STATES AND COMPLIES WITH DFARS EDITION 1998, SECTION 252.225-7014
 2. - FOREIGN MELT AND ROLLED IN THE UNITED STATES

TW METALS

REPORTS

JUL 7 - 2008

Clue

ACCEPTED BY

06/19/08 14:09:31

CONSIGNEE: Please Note - This consignment was turned over to carrier in first class condition, being correctly loaded, at no time our responsibility for loss or damage in shipment passed. For your protection please examine shipment as it arrived. If any shortage or damage is discovered, have a full description made by transportation agent en route before signing.

Material Safety Data Sheets for this product have been supplied to your Purchasing Department. For an additional copy phone 724-226-6577. CAUTION: Processing this material, fumes, dust, or solutions may cause lung disease. See Material Safety Data Sheets for further information.

WARNING

Les fiches d'information-sécurité de ce produit ont été fournies à votre département chargé des achats. Pour obtenir des exemplaires supplémentaires veuillez téléphoner au numéro suivant 724-226-6577. Attention: les traitements entourant la production de vapeurs, poussières, ou solutions peuvent être cause de malades pulmonaires. Pour plus de renseignements se référer aux fiches d'information-sécurité.

The above is a true copy of date on file. The material and test results conform to the sales contract and specification(s) as set forth in Allegheny Ludlum's Order Acknowledgment.

See Mr. Xerakis
Director, Corporate Quality Assurance

M491944582

NOTICE OF SHIPMENT/
PACKING LIST

CUST. ORD. NO. & DATE

01012647 FORMS DISTRIBUTION

SOLD TO 1 SHP TO SPEC
TO → | 1 | SHP TO | SPEC |CUST. CODE
04/30/08 110977

NEW REPEAT ORDER	CASTLE, IN.	SHIPPER NO.
82037-5	26	590040 GOVT CONTRACT
PRIME	SEC.	
DSO	DSO	
584		



Allegheny Ludlum

Allegheny Technologies

CERTIFICATE OF TEST

AL 6168-3 407

PRODUCT CODE	MILL. ORDER NUMBER	DATE SHIPPED
13020102060000	30-058-618	06/19/08
MATL	SHIPPING LOCATION	INVOICE
1124	NEW CASTLE	IN 076383
SHIP TO		

GRADE AND SPECIFICATIONS

ALLEGHENY STAINLESS STEEL TYPE 304-L SHEET C R COILS ANNEALED 2B FIN 3 EDGE (FMI 304L/304/302 ISSUE 7) (AMS 2248E) (AMS 5511H) (AMS 5513H) (AMS 5516P) (ASTM-A-262-02A PRA E/SCREEN PRA A) (ASTM-A-666-03) (S-400 DTD 10/31/07) (ASTM-A-240-07) (S-1000 DATED 1/2/08) (ASME-SA-240-07) (05/14/08 EXCEPT FMI 304L/304/302) (UNS S30403) (UNS S30200) (UNS S30400) (F-14, F-17, F-22, F-23, F-MASTER) (PWA 300 REV BH) (CONTROLLED TO PWA LCS REQUIREMENTS)

THIS CERTIFICATE OF TEST SHALL NOT BE REPRODUCED EXCEPT IN FULL WITHOUT THE WRITTEN APPROVAL OF THE COMPANY. THE RECORDING OF FALSE, FICTITIOUS OR FRAUDULENT STATEMENTS OR ENTRIES ON THE CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW. MATERIAL WAS MANUFACTURED IN ACCORDANCE WITH THE ALC QUALITY MANUAL REVISION 17 DATED 05/12/2008. ALC HOLDS SEVERAL QUALITY CERTIFICATIONS THAT INCLUDE ISO-9001, DIN EN 10204:2005 - 3.1. ALLEGHENY LUDLUM IS APPROVED AS A MANUFACTURER ACCORDING TO AD-MERK BLATT WO/TRD100 AND THE PRESSURE EQUIPMENT DIRECTIVE PED 97/23/EC. TESTING WAS PERFORMED AT ALC NADCAP AND ISO/IEC 17025 APPROVED LABORATORIES LOCATED AT NATRONA HEIGHTS, BRACKENRIDGE, LATROBE, MIDLAND, PA AND NEW BEDFORD, MA FACILITIES OR A NADCAP AND ISO/IEC ACCREDITED LABORATORY.

ALLEGHENY LUDLUM WORKS TO THE ROLLS ROYCE RR9000:SABRE REQUIREMENTS.

ALLEGHENY LUDLUM PERFORMS CHEMICAL ANALYSIS BY THE FOLLOWING TECHNIQUES:

C, S BY COMBUSTION/INFRARED

N, O, H BY INERT FUSION/ THERMAL CONDUCTIVITY

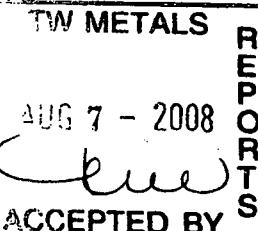
MN, P, SI, CR, NI, MO, CU, CB, CO, V BY WDXRF

B BY OES

AL AND TI (>=0.10%) BY WDXRF, OTHERWISE BY OES

PB, BI, AG BY GFAA

CARRIER - KAPLAN TRUCKING



Moor Metals Inc.

m-13610M49194458251013304 AMS 55B1386 # .050 X .36.00 X 120.00Allegheny Ludlum9447041J. J. Jureny
Authorized SignatureNY LUDLUM - 6/20/2008 08:27
/ CORPORATE QA DEPT.

Le ou ce produit ont été fournis à vous pour obtenir des exemplaires supplémentaires
à suivre 724-228-6377. Attention: les
tension de vapeurs, poussières, ou solutions
corrosives. Pour plus de renseignements se
bunite.

The above is a true copy of data on file. The material and test
results conform to the dates contract and specification(s) as set
forth in Allegheny Ludlum's Order Acknowledgement.

See Mr. Xerulus
Director, Corporate Quality Assurance